

Work Order ID 68651-2

Tuesday, April 19, 2011 2:23:58 PM

Page 1

Item ID: D205-708-011

Revision ID:

Item Name: Adjustable Engine Mount

Start Date: 4/19/2011 Start Qty: 4.00

Required Date: 4/29/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: CL

QC:

Date: 11/04/19

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

B80701

Rev C

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

8/16/15

CL 11-7-13

110



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 13912 for:
6 D3284-001 (B80702-1) Sleeve
2 D3284-003 (B80703-1) Stud
4 D3284-005 (B80704-1) Stud
6 D3284-007 (B80705-1) Stud
6 NAS509-12 Nut
6 NAS509L12 NutStud

To be assembled as per Dwg B80701 Rev. C
Possible Supplier: Northern Aero
Certificate of Conformity is required

11-04-19
(4)

Work Order ID 68651

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Item ID: D205-708-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Adjustable Engine Mount

Start Date: 4/19/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Receive & Inspect For Transit Damage: Ensure Certificate of Conformity is attached

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Inspect assembly. Visually inspect thread, fit and cad plating

135

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

Rec'd 4/19/11 (3)

(+3)
sch.

11/7/12 (30) \$

Work Order ID 68651

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Item ID: D205-708-011

Accept



Setup Start



Revision ID:

Item Name: Adjustable Engine Mount

Stop



Start Date: 4/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC4- 100% inspect kits for completeness

0.00



QC

Memo

0.00

8/15/15

(43)

Quality Control

150

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D205-708-011

Location: 21

PPP Rev: A

11/7/15 (30)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/7/18

ME
11-07-18

Quality Control

Picklist Print

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Page 1

Work Order ID: 68651

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount



Start Date: 4/19/2011

Required Date: 4/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C 06.01.31 Added MS206136C12 JLM/AP
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3284-001



Sleeve

Manufactured No

140

Each

2.0000

6

24

B68651

5

Location

Loc Qty

Loc Code

ST045

2

59910

2

D3284-003



Stud

Manufactured No

140

Each

6.0000

2

8

B68651

SP

Location

Loc Qty

Loc Code

ST045

6

32724

4

35656

2

D3284-005



Stud

Manufactured No

140

Each

5.0000

4

16

B68651

SD

Location

Loc Qty

Loc Code

ST045

5

39942

1

43645

4

D3284-007



Stud

Manufactured No

140

Each

4.0000

6

24

B68651

SP

Location

Loc Qty

Loc Code

ST046

4

59048

4

Picklist Print

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Page 2

Work Order ID: 68651

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 4/19/2011

Required Date: 4/29/2011

Start Qty: 4.00

Required Qty: 4.00

D3284-009

Manufactured No

140

Each

1.0000

6

24



Bearing

Location

Loc Qty

Loc Code

ST046

1

61802

1

140

Each

16.0000

1

4

D3284-011

Manufactured No



Bearing

Location

Loc Qty

Loc Code

ST046

16

60004

16

140

Each

98.0000

2

8

MS20613-6C12

Purchased No



RIVET

Location

Loc Qty

Loc Code

ST322

98

105433

98

140

Each

504.0000

8

32

MS20613-6C16

Purchased No



Rivet

Location

Loc Qty

Loc Code

ST322

504

114035

10

115358

494

140

Each

39.0000

4

16

MS20613-6C18

Purchased No



Rivet

Location

Loc Qty

Loc Code

ST322

39

19513

39

Shop Packet Print

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Picklist Print

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Work Order ID: 68651

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount



Start Date: 4/19/2011

Required Date: 4/29/2011

Start Qty: 4.00

Required Qty: 4.00

MS20613-6C19

Purchased

No

140

Each

0.0000

12

48

27

Rivet

NAS509-12

Purchased

No

140

Each

42.0000

6

24

Nut

Location

Loc Qty

Loc Code

ST280

42

15057

42

NAS509L12

Purchased

No

140

Each

38.0000

6

24

Nut

Location

Loc Qty

Loc Code

ST280

38

102296

29

15062

9



9x
MID7178 M112541
B 68651

B 68651

Tuesday, April 19, 2011 2:23:55 PM

Shop Packet Print

Page 3

SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



NOTE:

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH
 MIN Ft_u = 90 Ksi
 MIN Ft_y = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

CL 11/04/19

W10.68651

RELEASED
 2010-03-25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3284	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ADJUSTABLE ENGINE MOUNT	NTS
DATE	09.07.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ACS-NAI Ltd.

25 Dunlop Avenue
R2X 2V2 Winnipeg
Canada
Tel : 204-772-9922
Fax : 204-772-7568

Delivery No. : 1881
Delivery Date : 07/07/2011
SO No. : 24705
Your Reference : PO: PO13912
Delivery Method : FEDEX ACCT# 2351 4353 4
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention:Brigitte
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Item	Description Batch Number	Total Ordered	Unit	Qty Delivered	Delivery Date
ASSEMBLY B80702-1	ENGINE MOUNT KIT SLEEVE 08-1874 10-3000 11-2837	3 18	EA EA	3 18	07/08/2011 07/08/2011
B80703-1	7/8 STUD 08-2515	6	EA	6	07/08/2011
B80704-1	3/4" MALE STUD 08-1927	12	EA	12	07/08/2011
B80705-1	STUD 10-2599 11-2839	18	EA	18	07/08/2011
NAS509-12	NUT (.7500-16 UNJF-3B) 10-2706	18	EA	18	07/08/2011
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 08-1060	18	EA	18	07/08/2011
BACK ORDER					

5 units

Packages: 0

Gross Weight: 0.00

Net Weight:

Ordered by: Dart Aerospace Ltd.

Attention: Brigitte
1270 Aberdeen Street
Hawkesbury K6A 1K7
Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts
1270 Aberdeen Street
Hawkesbury K6A 1K7
Canada

0.00

Remarks**Certification Statement**

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted. PN: NAS 509-12 / NAS 509-L12 (18) EA.

Signature

Date:

7 July 2011



Engineering, Certification & Manufacturing

25 Dunlop Ave
Winnipeg, Manitoba, Canada, R2X 2V2
Ph: 204-772-9922 Fax: 204-772-7568

CERTIFICATE OF CONFORMITY

Form Tracking No. 24705-2

Work Order/Contract/Invoice
PO: PO13912

Cage Code: MFR L0555

Item	Description	Part No.	Quantity	Serial/Batch	Status
1	Sleeve	B80702-1	1	08-1874	manufactured
2	Sleeve	B80702-1	2	10-3000	manufactured
3	Sleeve	B80702-1	15	11-2837	manufactured
4	Stud	B80703-1	6	08-2515	manufactured
5	Male Stud	B80704-1	12	08-1825	manufactured
6	Stud	B80705-1	1	10-2599	manufactured
7	Stud	B80705-1	17	11-2839	manufactured

Remarks:

THESE ITEMS CONFORM TO DESIGN DATA B80702 (REV. A); B80703 (REV. A); B80704 (REV. A) AND B80705 (REV B), AS APPLICABLE.

New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.

Signature

Name R. D. WILLIAMSON

Date (dd mmm yyyy)
07 Jul 11

Used, Repaired or Overhauled Parts Certification

The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.

Signature

Name

Date (dd mmm yyyy)

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.

Work Order ID 76147***76147***

Page 1

November-08-11 9:23:34 AM

Item ID: D205-708-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Adjustable Engine Mount

Start Date: 11/08/11 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/08/11 Req'd Qty: 2.00

2

Customer:

Reference: for costing purposes

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B80701

Rev C

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

to pull purchased parts to correct costing

672.7

2-376-1658.

11-11-08

Picklist Print

November-08-11 9:23:34 AM

Page 1

Work Order ID: 76147

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Start Date: 11/08/11

Required Date: 11/08/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C 06.01.31 Added MS206136C12 JLM/AP
IPP Rev:D 07-12-12 as per ECN 1074 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B80702-1 Sleeve		Purchased	No				Each	0.0000		18			
B80703-1 Stud		Purchased	No				Each	0.0000		6			
B80704-1 stud		Purchased	No				Each	0.0000		12			
B80705-1 stud		Purchased	No				Each	0.0000		18			
D205-708-011 Adjustable Engine Mount		Manufactured	No				Each	0.0000		2			

68681
14 72690
14 72691

Item ID	Trans Date	Inv Change Amt	Reference
D205-708-011	12/05/09 18:10	0	
D205-708-011	12/05/09 18:10	0	Old value 0
D205-708-011	12/05/09 18:10	0	New value 3083.5416
D205-708-011	12/05/09 18:10	6167.0832	Item Revision Consolidation Automation; Acct#: 60100-50; Emp ID: INS007
D205-708-011	12/16/09 8:19	-3083.5416	Sales Order Line Number: 1, Required Date: 12/16/2009 12:00:00 AM
Required Quantity: -1	0	0	PURCHASED ITEMS
D205-708-011	1/06/10 9:50	3083.5416	
D205-708-011	1/06/10 9:50	-3083.5416	
D205-708-011	1/18/10 14:57	3083.5416	Work Order ID: 54900, Employee ID: LACE01
D205-708-011	1/18/10 15:56	-3083.5416	Sales Order Line Number: 1, Required Date: 1/19/2010 12:00:00 AM
Required Quantity: -1	0	0	PURCHASED ITEMS
D205-708-011	1/26/10 9:26	3083.5416	
D205-708-011	1/26/10 9:26	-3083.5416	
D205-708-011	1/26/10 9:27	-3083.5416	Sales Order Line Number: 9, Required Date: 1/26/2010 12:00:00 AM
Required Quantity: -1	0	0	PURCHASED ITEMS
D205-708-011	1/26/10 10:27	3083.5416	Sales Order Line Number: 9, Required Date: 1/26/2010 12:00:00 AM
Required Quantity: 1	0	0	PURCHASED ITEMS
D205-708-011	1/26/10 10:39	-3083.5416	Sales Order Line Number: 9, Required Date: 1/26/2010 12:00:00 AM
Required Quantity: -1	0	0	PURCHASED ITEMS
D205-708-011	1/26/10 15:08	3083.5416	; Acct#: 60100-45; Emp ID: LACE01
D205-708-011	1/26/10 15:08	-3083.5416	; Acct#: 60100-45; Emp ID: LACE01
D205-708-011	3/19/10 10:15	0	Old value 3083.5416
D205-708-011	3/19/10 10:15	0	New value 2494.6754
D205-708-011	3/19/10 10:15	7484.0262	Work Order ID: 54900, Employee ID: LAVO01
D205-708-011	4/27/10 12:34	2965.7106	2494.68 -> 3483.25
D205-708-011	5/18/10 14:08	-6966.4912	Sales Order Line Number: 1, Required Date: 5/18/2010 12:00:00 AM
Required Quantity: -2	0	0	PURCHASED ITEMS
D205-708-011	5/25/10 16:09	-3483.2456	Sales Order Line Number: 1, Required Date: 5/25/2010 12:00:00 AM
Required Quantity: -1	0	0	PURCHASED ITEMS
D205-708-011	6/24/10 13:51	3483.2456	Work Order ID: 59048, Employee ID: LAVO01
D205-708-011	6/24/10 14:02	0	
D205-708-011	6/24/10 14:21	-3483.2456	Sales Order Line Number: 3, Required Date: 6/23/2010 12:00:00 AM
Required Quantity: -1	0	0	PURCHASED ITEMS

6/24/10 14:02

D205-708-011	7/14/10 14:19	0 Old value 3483.2456	
D205-708-011	7/14/10 14:19	0 New value 2875.2160	
D205-708-011	7/14/10 14:19	5750.432 Work Order ID: 59048, Employee ID: LACE01	
D205-708-011	9/14/10 12:48	0 Old value 2875.2160	
D205-708-011	9/14/10 12:48	0 New value 2959.0425	
D205-708-011	9/14/10 12:48	5918.085 Work Order ID: 60587, Employee ID: LACE01	
D205-708-011	9/14/10 15:18	0	9/14/10 15:17
D205-708-011	12/02/10 10:36	5133.1632 2959.04 -> 4242.33	
D205-708-011	1/31/11 11:35	-4242.3333 Sales Order Line Number: 1, Required Date: 1/31/2011 12:00:00 AM	
Required Quantity: -1	0	0 PURCHASED ITEMS	
D205-708-011	4/19/11 16:04	-8484.6666 Sales Order Line Number: 1, Required Date: 4/19/2011 12:00:00 AM	
Required Quantity: -2	0	0 PURCHASED ITEMS	
D205-708-011	5/12/11 14:56	4242.3333 Work Order ID: 68651, Employee ID: FAUT01	
D205-708-011	5/13/11 7:46	0	5/13/11 7:46
D205-708-011	7/08/11 14:00	-4242.3333 Sales Order Line Number: 4, Required Date: 7/8/2011 12:00:00 AM	
Required Quantity: -1	0	0 PURCHASED ITEMS	
D205-708-011	7/08/11 14:00	-4242.3333 Sales Order Line Number: 2, Required Date: 7/8/2011 12:00:00 AM	
Required Quantity: -1	0	0 PURCHASED ITEMS	
D205-708-011	7/15/11 14:58	0 Old value 4242.3333	
D205-708-011	7/15/11 14:58	0 New value 1522.1536	
D205-708-011	7/15/11 14:58	4566.4608 Work Order ID: 68651, Employee ID: FAUT01	
D205-708-011	8/03/11 6:53	0 RMA ID : RA111255	
D205-708-011	8/03/11 6:53	0 RMA ID : RA111255	
D205-708-011	8/08/11 9:28	0 RMA ID : RA111255, Rework ID: 72690	
D205-708-011	8/08/11 9:28	0 RMA ID : RA111255, Rework ID: 72691	
D205-708-011	8/08/11 9:28	-1522.1536 Rework ID: 72690, Reason: , Employee ID: Kerr02	
D205-708-011	8/08/11 9:28	-1522.1536 Rework ID: 72691, Reason: , Employee ID: Kerr02	
D205-708-011	8/08/11 9:28	1522.1536 RMA ID : RA111255, Rework ID: 72690	
D205-708-011	8/08/11 9:28	1522.1536 RMA ID : RA111255, Rework ID: 72691	
D205-708-011	8/11/11 15:56	1522.1536 Work Order ID: 72690, Employee ID: GOLD01	
D205-708-011	8/11/11 15:57	1522.1536 Work Order ID: 72691, Employee ID: GOLD01	
D205-708-011	8/12/11 15:23	0	8/12/11 15:23
D205-708-011	8/12/11 15:23	0	8/12/11 15:23
D205-708-011	9/19/11 15:44	-1522.1536 Sales Order Line Number: 1, Required Date: 9/19/2011 12:00:00 AM	

Required Quantity: -1 0

D205-708-011 10/20/11 13:01

Required Quantity: -2 0

D205-708-011 11/08/11 9:19

D205-708-011 11/08/11 9:25

D205-708-011 11/08/11 9:25

D205-708-011 11/08/11 9:25

0 PURCHASED ITEMS

-3044.3072 Sales Order Line Number: 1, Required Date: 10/20/2011 12:00:00 AM

0 PURCHASED ITEMS

-3044.3072 Rework ID: 76147, Reason: , Employee ID: LACE01

0 Old value 1522.1536

0 New value 4140.7711

8281.5422 Work Order ID: 76147, Employee ID: LACE01

Accounting Labor Amount	Accounting Material Amount	Accounting Variable Burden Amount	Prod Fam
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS
0		0	0 PURCHASED ITEMS

[illegible]